

# Work Order ID 72225

Wednesday, July 20, 2011 8:59:48 AM



Page 1

Item ID: D6101-001

Revision ID:

Item Name: Saddle Billet

Start Date: 7/20/2011 Start Qty: 40.00

Required Date: 8/3/2011 Req'd Qty: 40.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: CL

Date: 11/07/20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O:

a) Description: Alluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.030"/-0.000"  $\pm$  +/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

CL 11/07/21 (40)

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure material certification is attached

11/14/11 (20)

# Work Order ID 72225

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Item ID: D6101-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 7/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

*CHK 11/08/11*

*20*

Memo

0.00

Ensure Material certification comply to Dwg D

130



Packaging

Packaging

Identify as per dwg & Stock Location: *PLAT 40*

0.00

*CHK 11/08/11*

*20*

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

*CK 11/08/11*

Memo

0.00

*11-08-11*  
*(20)*

# Picklist Print

Wednesday, July 20, 2011 8:59:45 AM

Page 1

Work Order ID: 72225

Parent Item: D6101-001

Parent Item Name: Saddle Billet




Start Date: 7/20/2011

Required Date: 8/3/2011

Start Qty: 40.00

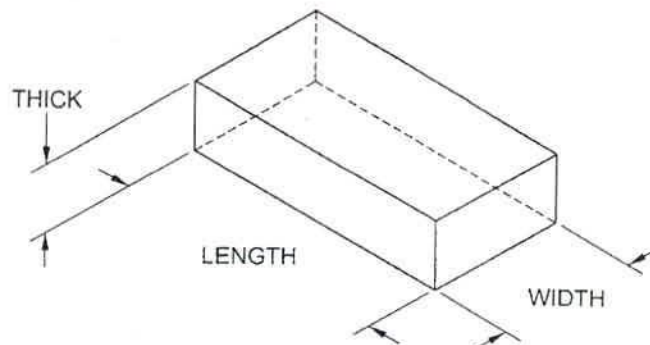
Required Qty: 40.00

Comments: IPP B: 01.05.04 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1	40			

*Handwritten signature: P. 11/2/9 60*

# SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

**B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

**RELEASED**  
09/07/15/W

*Handwritten:* CY 11/07/20  
W10: 72225

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**Castle Metals®**

A. M. Castle &amp; Co.

## PACKING SLIP

Page 1 of 1

Shipment No: 926568

<b>Ship From:</b> A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		
<b>Date Shipped</b> 08-AUG-2011		<b>F.O.B.</b> ORIGIN		<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN		<b>BOL No</b> 926568-2

**Shipment Details** Final Destination Branch - MON

<b>Order No</b> 1604887	<b>Line No</b> 1	<b>Item No</b> 752237.MO	<b>Description</b> 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12					
<b>Purchase Order No</b> 14554		<b>Part Number</b> YOUR ITEM NUMBER: D6101-001		<b>Ordered Qty</b> 20 PCS		<b>Invoice Qty</b> 20 PCS		
<b>Details</b>		<b>Mill</b>	<b>Heat Number</b> 589281	<b>Mech Id</b>	<b>PCS</b> 20	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty(LBS)</b> 154.83
<b>Delivery No.</b> 88620339								

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

## CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Valcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

1061390 0 Invoice No. Alcoa No. Item Page  
Ship Date B.L. No. 00000 1000133855-3 DS-38855-3  
2009-10-26 4323476  
P.O. No./Govt Contract No. Customer Alcoa Item  
14585 Ln#: 3 CASTLE METALS G041003428R14

Ship To: A M CASTLE & COMPANY  
3050 SOUTH HYDRAULIC  
WICHITA 67216 KS

Item Description  
3.0 IN TH (+.055 -.055) X 48.5 IN W (+.3125 -  
0.000) X 144.5 IN LN (+.5 -0.0) CAT D 164164 (N) A/T 7075-  
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,  
SAWED IAC 5857, EXC MRK A97075-60 REV 25 AMS-QQ-A-250/12 IS 2007 AMS-  
STD-2154 EXC MRK AMS4078 REV 3 EXC MRK ASTM E209  
REV 07 ASTM B594 REV 06 BSS7055 REV A  
EXC MRK MMS159 REV N FS21211 REV K ((MARKED!))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-  
40 % US1 CL A 3 MM CQR 0107687 REV 32 CUST REQ 09-10-  
25 \*\*\* W/E 09-10-31 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UCM	Inspector Clock Numbers
1	759932	585281	1423	1	PC	47091
2	759995	585281	1433	1	PC	47091
			2356	2		

Notes for CCR: 0107687.32  
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154 PRODUCT PRODUCED TO THE  
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.  
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.  
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PROD UCT  
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.  
Exception to Spec A97075-60 ; Revsn: 25 Issue: Letter dated 2008-12-11 from TUCKER, BONNIE to PLATTER, B.

CQR: 0107687 32 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	69.0	57.0
T7351	Elec. Cond. (EC) & MIN	38.0	PCT	

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
	Min			1.2		2.1	0.18	5.1			REMAIN

# Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

## CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per

Malcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

1061390	0					Page 2
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item		
2009-10-26	4323476	00000	1000133855-3			DS-38855-3
P.O. No./Govt Contract No.		Customer	Alcoa Item			
14685 Ln#: 3		CASTLE METALS	G041003428R14			

CQR: 0107687.32 -Specification Limits (cont.) -----  
Lot: 589281 - Mechanical, Physical, Metallography, Quantometer Results -----

	No->	UTS	TYS	EL4D
Temp	Dir	KSI	KSI	PCT
T7351	Long Transv.	3	72	61.3
			71.9	61.3
			71.6	61
				11

T7351 Elect Cond 1IACS 40.8 40.9 41.0 PCT

Cast Number	Chemical - CES	SI	FE	CU	MN	MG	CR	ZN	TI
H4588024	Actuals	0.06	0.30	1.6	0.02	2.4	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States